



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3584-1
Job Sheet 201681



Part No: D3584-1

Job Qty: 4 pcs

Part Name: Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Due Date: 10/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 07.06.12 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	10/25/19		0.00	2.00	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		TP
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	4 pcs	10/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	4 pcs	10/25/19		0.00	1.01	Handfinish - 1 - 1 - B4B		BE B19-10-23
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		



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CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: 8225195



Part: D3584-1

Job No: 201681

Serial No/Batch: 8225195

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/22/19

10/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	4 pcs	10/25/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE TF
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	

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10/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 7 - 79	
140 Packaging 3-1 - Stock - B4B	4 pcs	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	TF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				150 QC 21 - SA	4 pcs
QC 21 - SA - 70	21				
QC 21 - SA - 53	9-35				
	OCT 23 201				

TF

DAS

21

9-39

OCT 23 2019

Part Op 100 - 1-Cut to Length as per Dwg D3584 2-Drill Pilot Holes using DT8960 Drill Jig 3-Open pilots to 1.000" as per Dwg
 Descriptions: D3584 4-Deburr

110 - (QC5- Inspect part completeness to step on W/O)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

140 - (Identify as per dwg & Stock Location: LG002), LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	4 pcs (1 ea)	100-Skidtubes - 1	B156812

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2963-125	4	35	0

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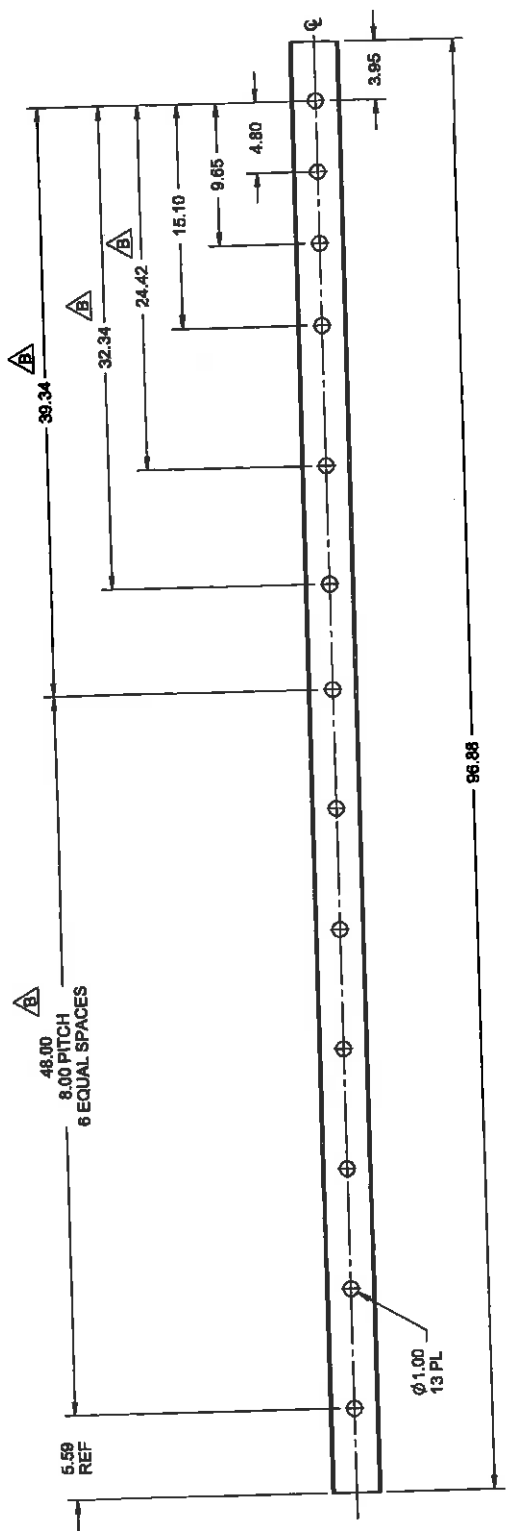
10/8/2019

Part Specifications

Specifications could not be found.

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8 7 6 5 4 3 2 1



RELEASED
2015-06-08
ECA 15-551

D3584-1 WEB

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 221081 MJS
1410-08

- NOTES:
- 1) MATERIAL: MAKE FROM D2983-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 006 4.1
 - 3) TOLERANCES: PER DART QSI 019 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.08 lbs

B	24.42 WAS 23.42 32.34 WAS 31.34 & (48.00 WAS 66.00 (24.42-1 & 32.34-1) ADDED 38.34	RF	16.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.02.20		

APPROVED
DART AEROSPACE USA, INC.
KENT, WA

REV. B	DRAWING NO.	SHEET 1 OF 1
	D3584	
SCALE	TITLE	NTS
	WEB	

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (QS1042)

QTY Affected: _____

Sequence #: _____

Date: _____

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Root Cause	Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Operator	☐	☐	☐	☐
Manufacturing Process	☐	Misaligned/off center	Folio/Program	Outside Tolerance
Equip/Tooling	☐	BOM/Route	Grain Direction	Drawing
Handling/Preservation	☐	Broken/Damage/Defect	Weld	Finish
Material	☐	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Product Improvement	☐	Drill Holes	Out of Sequence	Misread
Process Improvement	☐	Fit/Function	Off-set/Set-up	
Human Factors	☐			

Other/Details: